

Date: Thursday, 9/20/2007 3:27:01 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BUSHING
Job Number : 34743	
Estimate Number : 12984	
P.O. Number : <i>N/A</i>	Part Number : D36201
This Issue : 9/20/2007 S.O. No. : <i>NA</i>	Drawing Number : D3620 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 33873	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 10/3/2007
Checked & Approved By : <i>[Signature]</i>	Qty: 30 Um: Each
Comment : Est A 07.08.09 new issue EC verified by: JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M303R0625	303 Round Bar 0.625"
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Comment: Qty.: 0.1943 f(s)/Unit Total : 5.8275 f(s)

Material: Ø0.625 AISI 303 SS Rod (M303R0625)

Batch: *14105267* *Pq 07/09/24 M15267* *5.6'*

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL

Machine as per folio FA703

Deburr and tumble

24 07/09/24

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*24 07/09/24**(31)*

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.F. 07/09/24 (31)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *5110**[Signature] 07/09/24 25 (31)*

6.0	QC21	FINAL INSPECTION/W/O RELEASE
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*(31)*

Comment: FINAL INSPECTION/W/O RELEASE

12 07/09/05

Job Completion

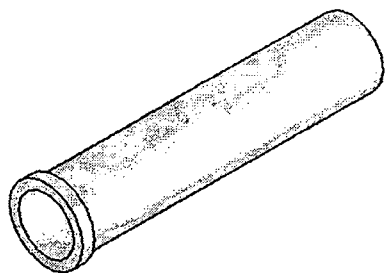
*[Signature] 07/09/24*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 01/09/25
 QA: N/C Closed: _____ Date: _____

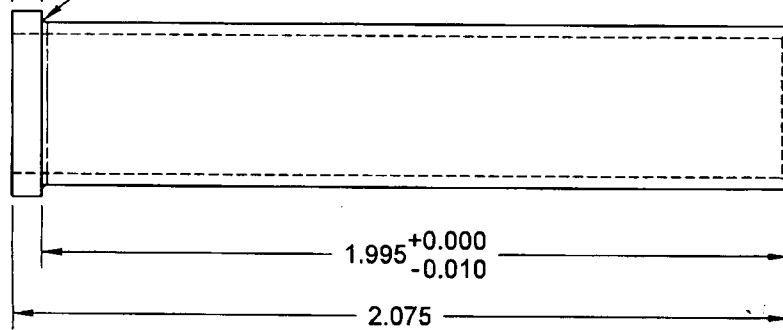
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

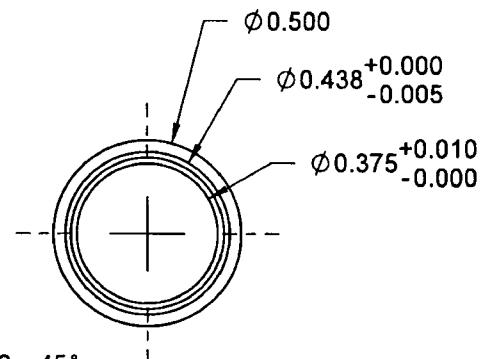


0.080
(REF)

R0.02



CHAMFER 0.02 x 45°
(ALL AROUND INSIDE)



D3620-1 BUSHING

RELEASED
07.08.07

NO. 347143
WORK ORDER
SUBJECT TO AMENDMENT
WITHOUT NOTICE
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND TUBING
(REF DART SPEC M304TR) OR
AISI 303 STAINLESS STEEL ROUND BAR
(REF DART SPEC M303R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3620-1" USING FINE POINT
PERMANENT INK MARKER
- 7) WEIGHT: 0.03 lbs

A	NEW ISSUE	CB	07.07.19
REV.	DESCRIPTION	BY	DATE
DESIGN	CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CB		
CHECKED	CE	DRAWING NO.	REV. A
MFG. APPR.	BE	D3620	SHEET 1 OF 1
APPROVED	#	TITLE	SCALE
DE APPR.	#	BUSHING	2:1
DATE	07.07.19	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DART AEROSPACE LTD		Work Order:	
Description: Crosstube Assembly		Part Number:	
Inspection Dwg:	Rev:	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.075	+/- .010	2.075				
	1.995	- .010	1.989				
	.080	+/- .010	.084				
	R.020	+/- .030	R.020				
	.500	+/- .010	.500				
	.438	- .005	.435				
	.375	+ .010	.377				
SIDE B							

Measured by: RP	Audited by: J.F.	Prototype Approval:	N/A
Date: 07/09/24	Date: 07/09/24	Date:	N/A
Rev	Date	Change	Revised by Approved
A		New Issue	KJ/JLM